

# Work Order ID 81711

March-19-12 8:41:21 AM

**\*81711\***

Page 1

Item ID: D4353-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw Insert  
 Start Date: 29/03/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 29/03/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4353	B

120	FLOW WATER JET	0.00							
<b>*120*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D4355-3 File Blank: 5.125" x 4.375" x 1.00"								

1312-3-24

(6)

130	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*130*</b>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB051 and Dwg FOLIO REV: <u>AA</u> DWG REV: <u>B</u> 3-Deburr								

SL 12/04/05

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	SL	12/04/05		6	0		
150 <b>*150*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	OK	12/04/05		6	0		
151 <b>*151*</b> Packaging Packaging	Identify as per dwg & Stock Location: <b>SI/39D</b>  Memo	0.00 0.00							

Ⓢp 12-0405.

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Page 3

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 12/04/05  
 MLJ 12/04/05

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**NOTE:** Date & initial all entries

# Picklist Print

March-19-12 8:41:25 AM

Page 1

Work Order ID: 81711

\*81711\*

Parent Item: D4353-3

\*D4353-3\*

Parent Item Name: Bearpaw Insert

Start Date: 29/03/2012

Required Date: 29/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-04-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	642.5059		0.842105		1.5	

\*MUHMWB10\*

UHMW 1" Black

\*\*

1312-3-24

Location

Loc Qty

Loc Code

MAT018

385.3815789

120035

67.7815789

120401

197.6

120972

120

MAT019

257.1243158

117321

74.6

117738

93.28

117819

83.3

118814

1.5

119145

4.44431579

120401

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

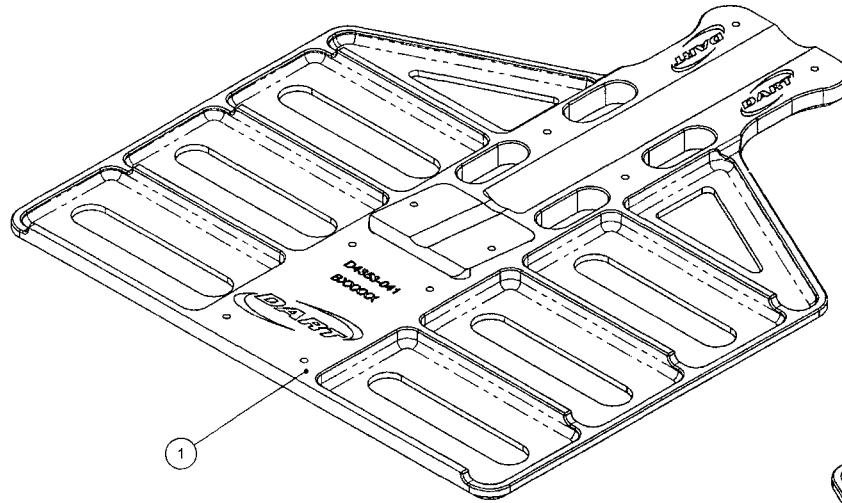
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

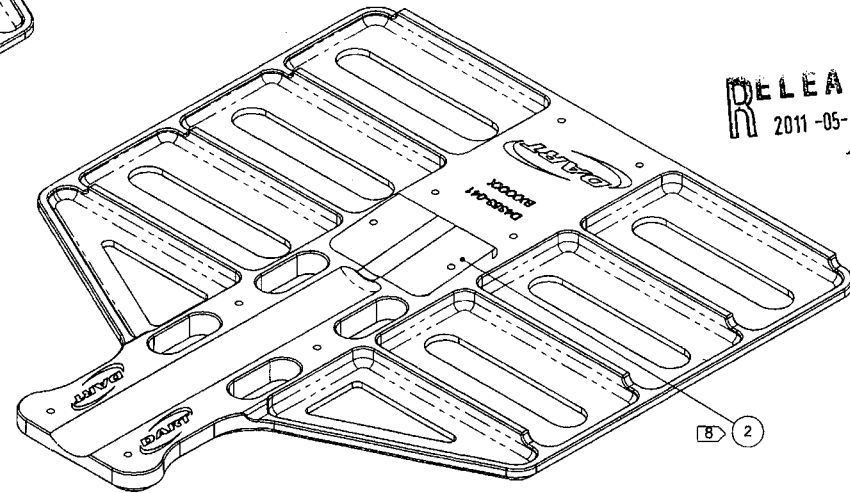




**D4353-041 429 BEARPAW ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81711 MLC  
12/03/19

ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT



RELEASED  
2011-05-24  
NP

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 7.45 lbs
  - 8) PRESS FIT

B	SHT 1 WEIGHT CORRECTED WAS 8.24 lbs. SHTS 1-3 DART LOGOS UPDATED. SHT 2, ZONE B8, AFT POCKET REDUCED. RIB INCREASED IN HEIGHT. SHT 3 SECTS. B,C & D RIB INCREASED IN HEIGHT.	AJS	11.04.26
A	NEW ISSUE	AJS	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MP	DRAWING NO. REV. B	
MFG. APPR.	MP	D4353 SHEET 1 OF 4	
APPROVED	MP	TITLE SCALE	
DE APPR.	MP	429 BEARPAW ASSEMBLY NTS	
DATE	11.04.26	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

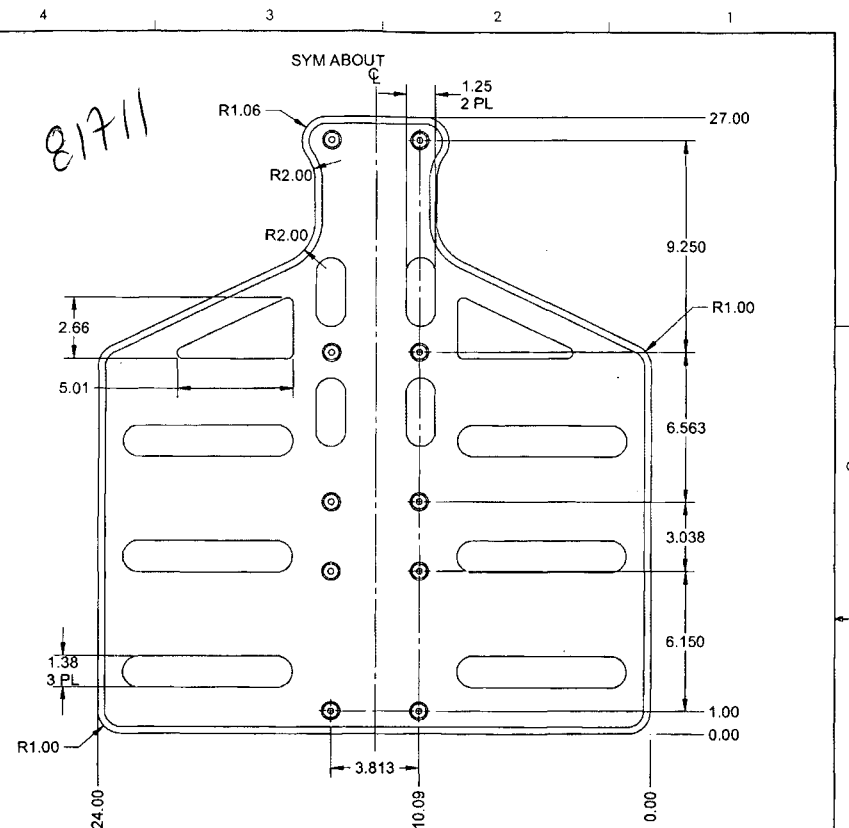
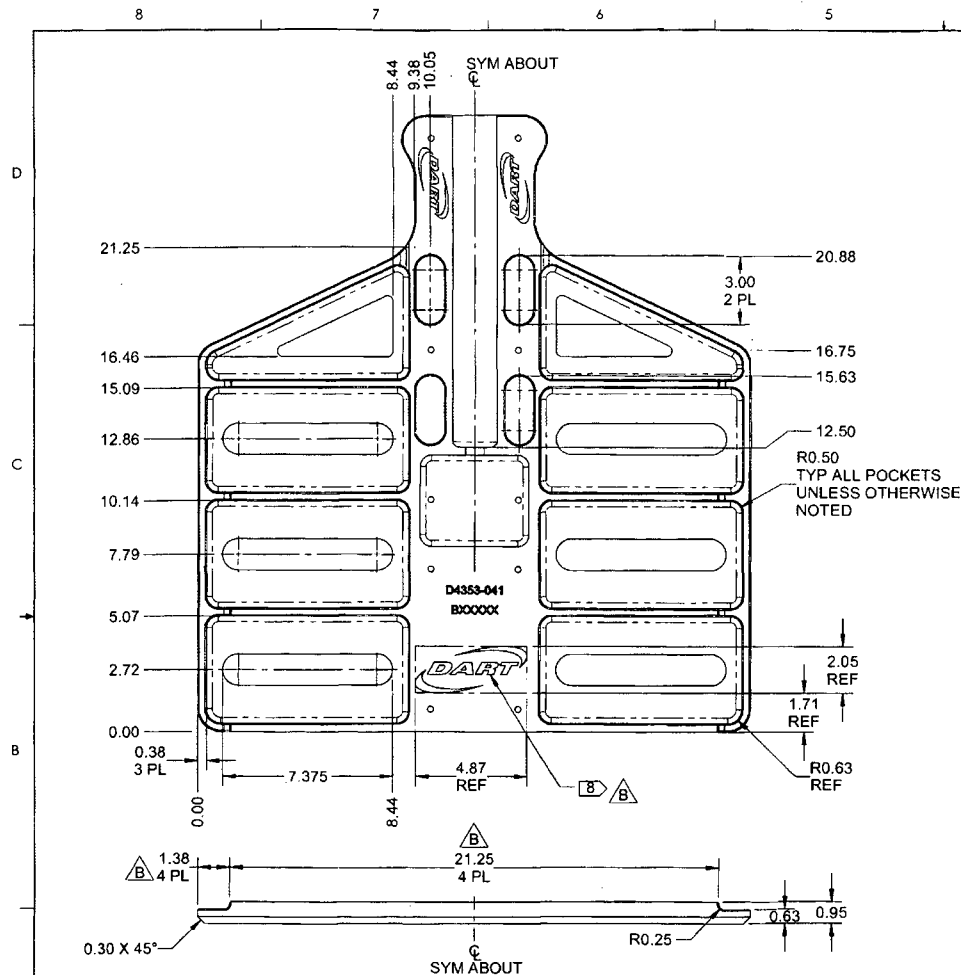
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4353-1 429 BEARPAW**

**RELEASED**  
R 2011-05-04 D

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART ASSEMBLY P/N "D4353-041" AND B/N "BXXXXX" 0.005 - 0.010 DP AS SHOWN
- 7) WEIGHT: 7.07 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP.

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4353</b>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>429 BEARPAW ASSEMBLY</b>	NTS
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# Dart Aerospace Ltd

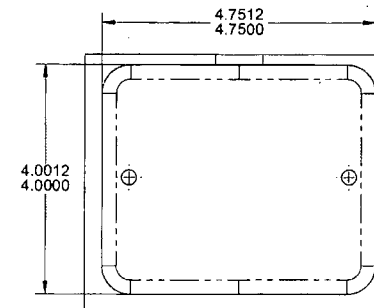
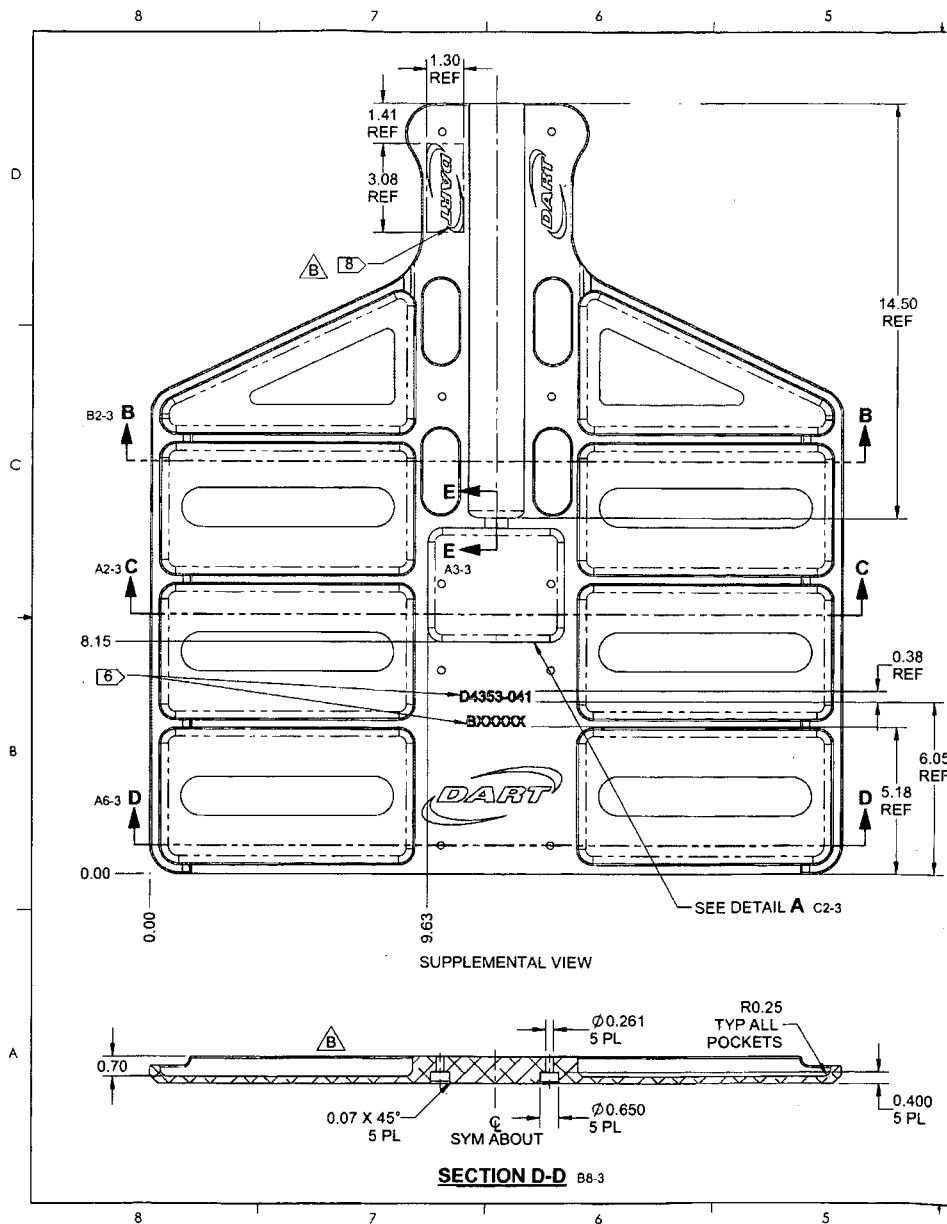
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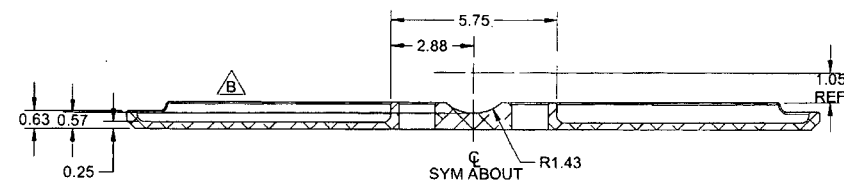
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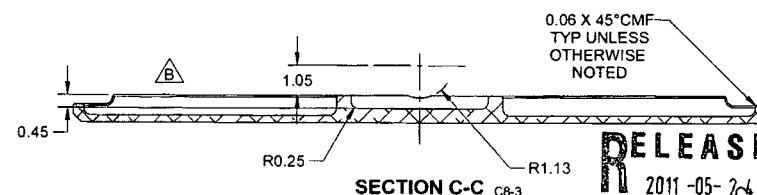
**NOTE:** Date & initial all entries



**DETAIL A** A5-3  
(SCALE 2X)



**SECTION B-B** C8-3



**SECTION C-C** C8-3



**SECTION E-E** C6-3  
(SCALE 2X)

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
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**RELEASED**  
2011-05-30  
*[Signature]*

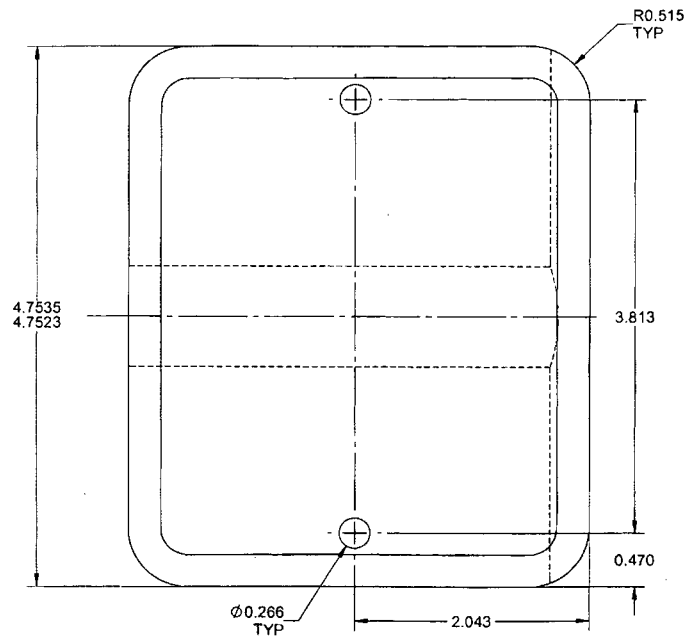
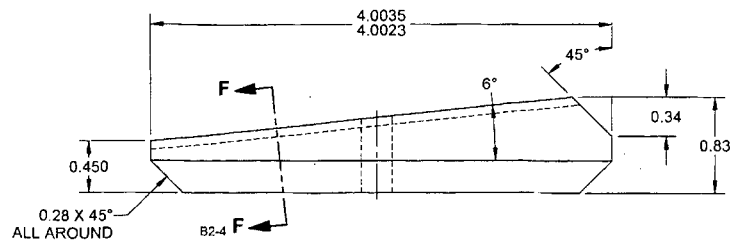
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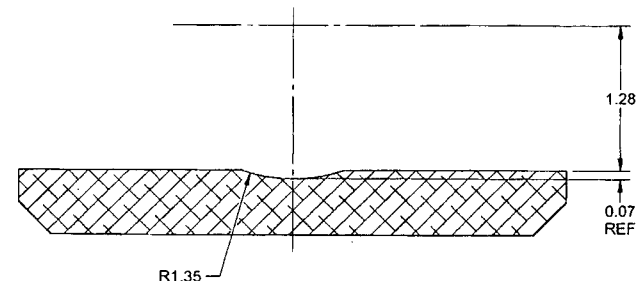
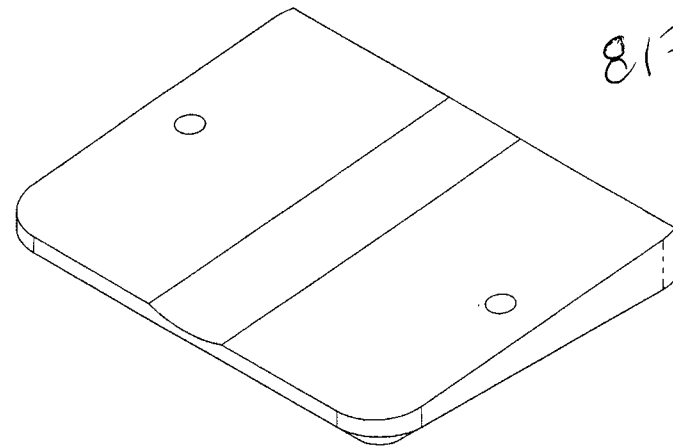
**NOTE:** Date & initial all entries



**D4353-3 429 BEARPAW INSERT**

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs



**SECTION F-F C7-4**

**RELEASED**  
2011-05-30

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4353</b>	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>429 BEARPAW ASSEMBLY</b>	NTS
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